

Work Order ID 80633

80633

Page 1

February-24-12 3:21:18 PM

Item ID: D119-675-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step RH

Stop *NS2*

Start Date: 24/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/27

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-675-012 CHG004

110

0.00

110

Pick Kit

Packaging

Memo

0.00

Packaging

120

0.00

120

QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/2/11/11

443/19 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

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Start Date: 24/02/2012 Start Qty: 2.00

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Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-675-012
Location: _____*S/ 12-4-11*

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/4/12
mc
12-04-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP Rev:E change to rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3043-042

D3043-042

Step Weldment RH, A119

D2182B032

D2182B032

Rubber Cushion

Manufactured

No

110

Each

0.0000

1
**

2

Manufactured

No

110

Each

14.0000

4
**

8

Location

ST402

Loc Qty

14

Loc Code

63469

4

73932

10

Manufactured

No

110

Each

311.0000

8
**

16

Location

ST007

Loc Qty

311

Loc Code

78589

311

Manufactured

No

110

Each

28.0000

4
**

8

Location

FG

Loc Qty

10

Loc Code

27991

10

ST012

18

76948

18

D2274

D2274

Radius Block

Manufactured

No

110

Each

311.0000

8
**

16

D2617-3

D2617-3

Bushing

Manufactured

No

110

Each

28.0000

4
**

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

D2617-5

Manufactured No

110

Each

25.0000

D2617-5

Spacer

**

8

16

1881814

Location

Loc Qty

Loc Code

FG

10

31756

10

ST018

15

77502

15

77502 15x

D2732-032

Manufactured No

110

Each

10.0000

D2732-032

RUBBER CUSHION

**

1

2

15x

Location

Loc Qty

Loc Code

ST

10

70987

10

70987

D3041-1

Manufactured No

110

Each

9.0000

D3041-1

Clamp

**

4

8

15x

Location

Loc Qty

Loc Code

ST462

9

77050

9

77050

D3041-3

Manufactured No

110

Each

28.0000

D3041-3

Clamp

**

2

45

12/3/12

Location

Loc Qty

Loc Code

ST462

28

51114

8

76997

20

76997

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3042-1
D3042-1

Manufactured No

110 Each

28.0000

4 8

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST457

28

77487

28

110 Each

246.0000

4 8

**

[Handwritten signature]

AN4-11A
AN4-11A

Purchased No

Location

Loc Qty

Loc Code

ST356

246

117872

46

118706

100

120731

100

110 Each

693.0000

8 16-L

**

[Handwritten signature]

AN4-12A
AN4-12A

Purchased No

Location

Loc Qty

Loc Code

ST357

693

115422

4

118628

39

119775

50

120423

600

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-15A

Purchased

No

110

Each

515.0000

4

8

**

AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

100

120449

100

ST358

415

118706

15

120187

200

120422

200

110

Each

8.0000

12

24

**

AN960JD416

NAS1149D0463J

Purchased

No

AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

8

116289

8

110

Each

4,942.000

12

24

**

MS21042141

MS210421 4

Nut

Location

Loc Qty

Loc Code

ST300

4942

117441

59

117601

157

118451

133

119017

200

119075

4393

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011	11.5 lb	- 32.4 in	- 373 in-lb	121.3 in	1395 in-lb
<i>HELI-ACCESS-STEP™</i> , LH	5.2 kg	- 1.28 m	- 6.7 m-kG	3.08 m	16.0 m-kG
D119-675-012	11.5 lb	+32.4 in	+373 in-lb	121.3 in	1395 in-lb
<i>HELI-ACCESS-STEP™</i> , RH	5.2 kg	+1.28 m	+6.7 m-kG	3.08 m	16.0 m-kG

5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	<i>HELI-ACCESS-STEP™</i> , LH
	X	D119-675-012	<i>HELI-ACCESS-STEP™</i> , RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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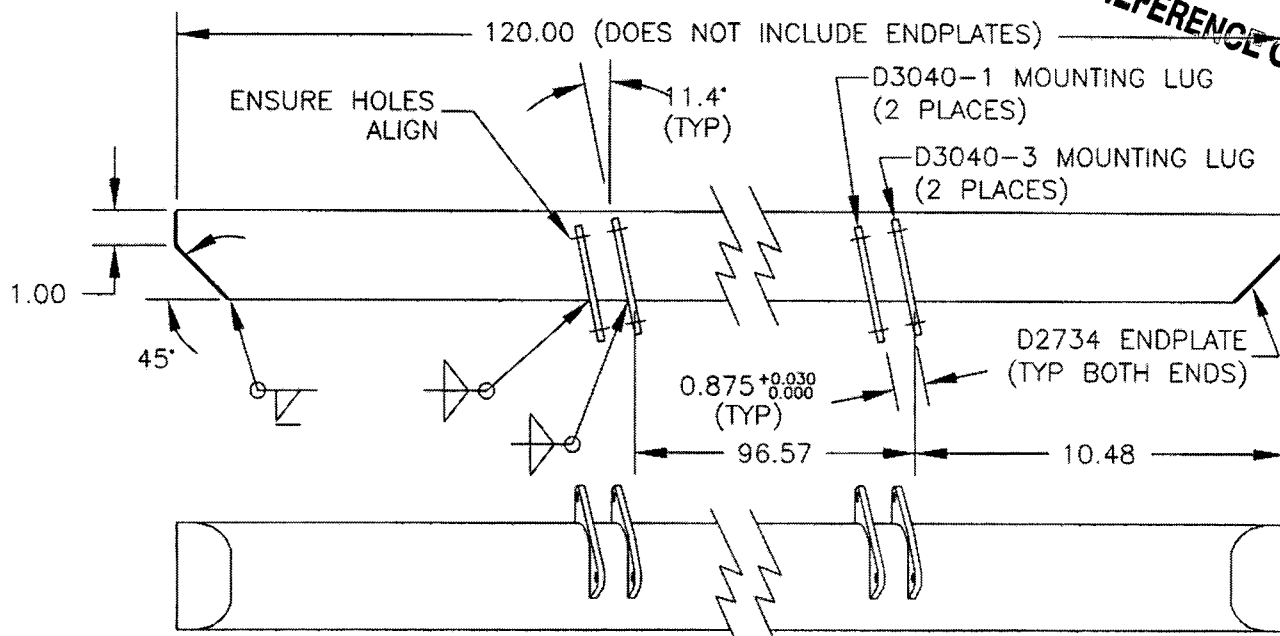
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Revision: B

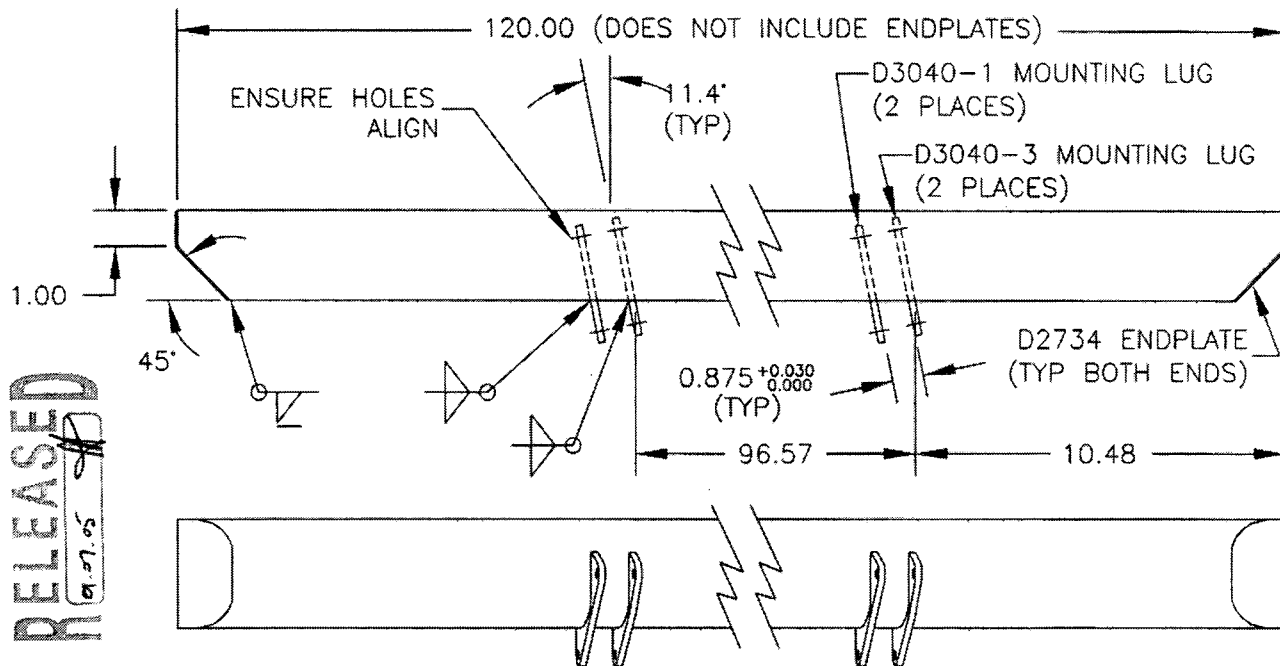
Date: 07.10.23



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED
01.07.05

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